

chuck



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5658-3

Job Sheet 201973



Part No: D5658-3

Job Qty: 6 pcs

Part Name: Fwd Extension



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/28/19

Description: SIOP

Type: Stock

Note: DWG D5658 REV:A IPP REV A 19.03.14 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Doosan - 1	6		11/28/19	1.00	3.00	Doosan - 1		<i>De</i>
		pcs							
120	QC 2	6		11/28/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S226759



Part: D5658-3

Job No: 201973

Serial No/Batch: S226759

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/27/19

Op 110 Doosan-1
Next time the job
Should take 1h for 6 part
+ 1h set-up

130 QC 8	6 pcs	11/28/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	19-11-08
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	11/28/19	0.00 1.50	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	NOV 12 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

Plex 10/17/19 9:03 AM Dart.lajeunesse.marie

					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	6 pcs	11/28/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
160 Packaging 3-1 - Stock - B4B	6 pcs	11/28/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	

DAS
81
9-89

NOV 13 2019

DAS
74
9-89

NOV 18 2019

10/17/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

170 QC 21 - SA

6
pcs

11/28/19

0.00 0.00

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

DAS
21

NOV 19 2019

Part Op 110 - 1-CUT BLANKS AT 12.00" 2-Machine as per folio FB _____ FOLIO REV: _____ DWG REV: _____

Descriptions: 3-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - QC7-Inspect Chemical Conversion Coat

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item
M6061T6R2.750Component Name
6061-T6 Round Bar 2.750"Quantity
6 ft (1 ea)Operation
110-Doosan - 1Container
SL31150

Job Allocations

Operation
110-Doosan - 1Component Part
M6061T6R2.750Required
6Inventory
16Allocated
0

Part Specifications

Specifications could not be found.

Plex 10/17/19 9:03 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (Q51042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

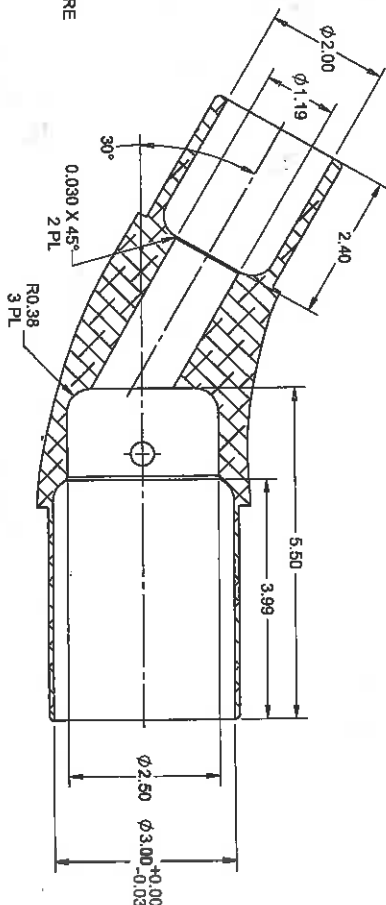
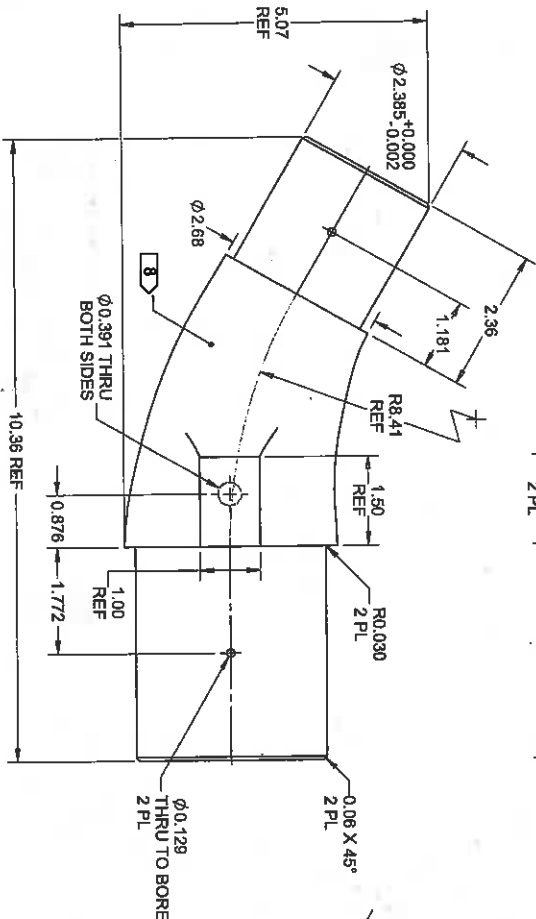
Operator ☐ ☐ ☐ ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐
Material ☐ ☐ ☐ ☐ ☐ ☐
Product Improvement ☐ ☐ ☐ ☐ ☐ ☐
Process Improvement ☐ ☐ ☐ ☐ ☐ ☐
Human Factors ☐ ☐ ☐ ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐
Bending ☐ ☐ ☐ ☐ ☐ ☐
Crushing ☐ ☐ ☐ ☐ ☐ ☐
Cracks ☐ ☐ ☐ ☐ ☐ ☐
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐
Mislabeled ☐ ☐ ☐ ☐ ☐ ☐
Other/Details: _____

Contamination ☐ ☐ ☐ ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐
BOM/Route ☐ ☐ ☐ ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐
Drill Holes ☐ ☐ ☐ ☐ ☐ ☐
Fit/Function ☐ ☐ ☐ ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐ ☐ ☐ ☐
Folio/Program ☐ ☐ ☐ ☐ ☐ ☐
Grain Direction ☐ ☐ ☐ ☐ ☐ ☐
Weld ☐ ☐ ☐ ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐ ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐ ☐ ☐ ☐
Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐
Drawing ☐ ☐ ☐ ☐ ☐ ☐
Finish ☐ ☐ ☐ ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐
Misread ☐ ☐ ☐ ☐ ☐ ☐



SECTION A-A

D5658-1 FWD TRANSITION

- NOTES:
1) MATERIAL: 8061-16T66/1766/1762 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 41774/128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T68 OR M6061T6R OR M6061T7H
2) FINISH: CHEMICAL CONVERSION COAT PER DART CSI 005 4.1
3) TOLERANCES: PER DART CSI 019 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART PIN "D5668-1" AND SERIAL NUMBER PER DART CSI 044 6.1
7) WEIGHT: 2.89 lbs
8) ALL NON-DIMENSIONED FEATURES WITHIN ± 0.030 OF CAD FILE "D5668-1-REVA.STEP"

2019 SEP 10 MD
ECW/19-890

APPROVED

A-	NEW ISSUE		ZF	NOV 28
REV.		DESCRIPTION	BY	DATE
DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OH		
DRAWING	MMW	DRAWING NO.	REV. A	
CHECKED	ZF	D5658	SHEET 1 OF 1	
MFG. APPR.	RQ	TITLE	SCALE	
APPROVED	NO	FWD END	NTR	
DE APPR.	DS	COMPANY: DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR THE PURPOSES SPECIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.		
DATE	18.11.28			